



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67014**

Thursday, March 03, 2011 11:51:50 AM



Page 2

Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>13639</u> Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached								
160 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	INSPECT CERTS								

CY 11/03/10 (22)

P4/3/21 (22)

counts  
(+72)

# Dart Aerospace Ltd

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Thursday, March 03, 2011 11:51:50 AM



Page 3

Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Install Insert as per Dwg D2348

ES 4/04/14 (22)

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

ml 11 04 14 (22)

200

0.00



Identify as per dwg &amp; Stock Location: 11

Packaging

Memo

0.00

Packaging

11/4/14 SP 220

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 67014**

Thursday, March 03, 2011 11:51:50 AM



Page 4

Item ID: D2348

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/18  
ME  
11-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, March 03, 2011 11:51:57 AM

Page 1

Work Order ID: 67014

Parent Item: D2348

Parent Item Name: Wearplate

Start Date: 3/3/2011


Required Date: 3/7/2011

Start Qty: 16.00

Required Qty: 16.00


Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM  
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	139.5000	0.0198	0.333474			
													

6061-T6 .063 Sheet

Location	Loc Qty	Loc Code
MAT	105.6	
116308	28.6	
116623	77	
MAT21	33.9	
113608	33.9	

D3996-FE-832-EF		Manufactured	No			180	Each	61.0000	4	64			
													

Self-Clinching Fastener

Location	Loc Qty	Loc Code
ST107	61	
54162	7	
65462	54	

B 67908

116623

SB 11/04/12

88

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

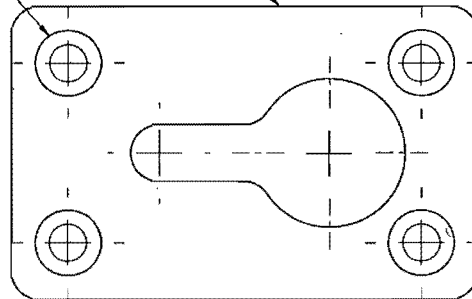
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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

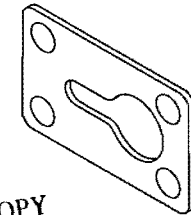
D3996-FE-832-EF  
SELF-CLINCHING FASTENER  
4 PL

D2348F



**D2348 WEAR PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67014  
RL1103.3



**RELEASED**  
2009-11-09  
*AW*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG  
7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>97</i>		
CHECKED	<i>97</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>97</i>	D2348	SHEET 1 OF 2
APPROVED	<i>97</i>	TITLE	SCALE
DE APPR.	<i>97</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

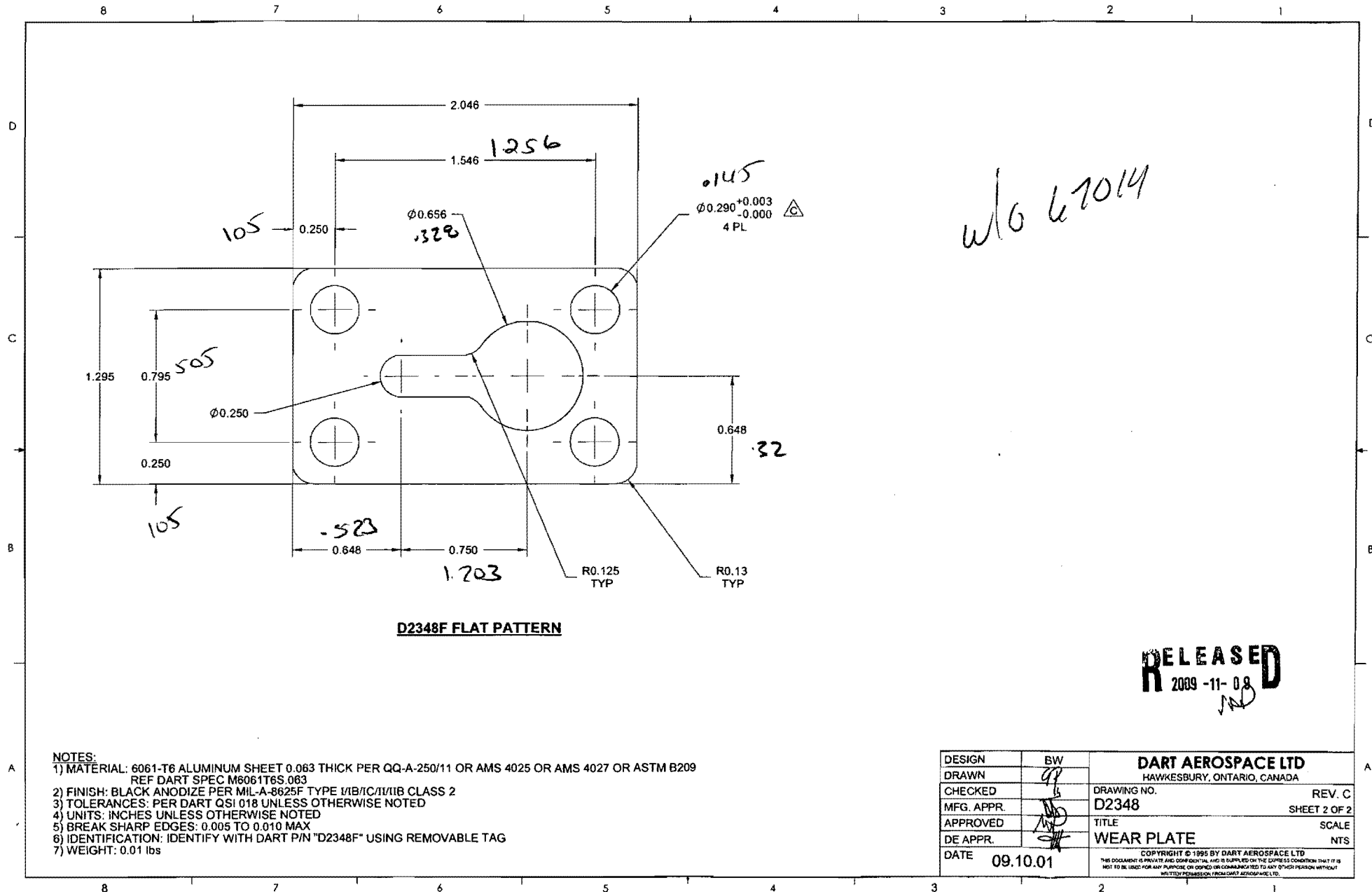
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**RELEASED**  
 2009-11-08  
 JAD

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13639**

Purchase Order Date 3/10/2011

PO Print Date 3/10/2011

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.  
21 AVIATION ROAD  
POINTE CLAIRE, QC H9R 4Z2  
CA

Contact Name

Vendor Phone

514 429 7777

Vendor Fax

514 429 5108

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

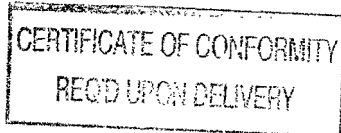
**FAKED**  
CS110311

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	67014	D2348 WEARPLATE	3/17/2011 Yes	22.00	FedEx PI collect	\$5.4545	\$120.00

Special Inst: FINISH: BLACK ANODIZE PER MIL-A-  
8625F  
TYPE I/IB/IC/II/IIB CLASS 2

PO Total:

\$120.00



Change Nbr: 1

Change Date: 3/10/2011

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable





21 chemin de l'Aviation, Pointe-Claire

QC H9R 4Z2

Canada

Phone:514-429-7777 Fax:514-429-5108

EMail:info@tnminc.ca

# Packing Slip

DATE

PACKING SLIP #

3/18/2011

- 89131



BILL TO:

SHIP TO:

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
13639	0094	NET 30		3/18/2011	Purolator		130749-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
22	22	0	P/N:D2348 TNM-REV:P1 Minimum Charge

Sign Here: \_\_\_\_\_

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.





# Anodisation & Peinture TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2  
Telephone 514-429-7777 Fax 514-429-5108  
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 89131



3/18/2011

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY ON K6A 1K7

PURCHASE ORDER /  
NO. DE COMMANDE: 13639

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	22	22	P/N:D2348 TNM-REV:P1 B67014 MAT'L: ALUMINIUM	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8 u103 121

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.  
All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filled and are available for viewing upon request.  
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.  
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed: \_\_\_\_\_


Directeur de la Qualité / Q.A. Manager

